



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D412-742-041
Job Sheet 177478



Part No: D412-742-041

Job Qty: 1 ea

Part Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) & OEM Cyl. Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/14/18

Job Tracking No:

Due Date: 6/21/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D3391-041 REV J SHEETS 1,2 IPP Rev A 05.10.13 New Issue KJ/JLM IPP Rev 06.02.13 ECN 773 dwg
@ rev.D EC IPP Rev:C 07-05-28 As per Rev F JLM IPP rev D 07.11.01 ecn 1053p EC IPP rev E 07.11.27 ecn
1072 EC verified:DD IPP Rev:F 08-09-08 ecn 08-510 DD verified:EC IPP Rev:G 10.02.24 as per ECN10-514
DD verified: EC IPP Rev:H 11.11.01 as per DS19517 REV.B DD verified:EC IPP REV:I 16.05.02 AS PER DWG
REV.J DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/21/18	0.00	0.00	Start Up Container		JL 18-7-19
110	HandFinish	1 pcs		6/21/18	0.00	3.77	HandFinish4		JL 18-7-19
120	QC	1 pcs		6/21/18	0.00	0.00	QC5		38
125	DC	1 pcs		6/21/18	0.00	0.00	DC		9-89 DAS
130	Packaging	1 pcs		6/21/18	0.00	0.00	Packaging3-2		JRB 28
140	QC21-FG	1 Ea		6/21/18	0.00	0.00	QC21		JUL 20 2018 89

Part Op 110 - 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with
Descriptions: saddle holes for proper alignment. using 7/16" "T" Pins. A/R Sikaflex-241/-291 18/12 Expiry date: 18/12
18/12 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped
with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no
sikaflex. A/R Sikaflex-241/-291 18/12 Expiry date: 18/12 3-Remove "T" pins once sikaflex is dry. 4-
Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon

125 - If D412-742-041 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-041 CHG007

130 - Identify and pack for shipping as per PPP D412-742-041 Location : FG073

Job BOM					004516
Part / Item	Component Name	Quantity	Operation	Container	
AN3C4A	Bolt	24 Ea (24 ea)	90-Start up Operation	5068642	
AN3C6A	Bolt	4 Ea (4 ea)	90-Start up Operation	5076000	
AN5C7A	Bolt	10 Ea (10 ea)	90-Start up Operation	5076003	
D3391-011	Fwd Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5076901	
D3391-013	Mid Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5078419	
D3391-015	Aft Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5076901	
D3672-3	Washer, Phenolic	4 Ea (4 ea)	90-Start up Operation	F132639	
D4095-041	Wearplate Fwd	1 Ea (1 ea)	90-Start up Operation	F164212-1	
D4095-043	Wearplate Aft	1 Ea (1 ea)	90-Start up Operation	5059945	
D4095-045	Wearplate Center	1 Ea (1 ea)	90-Start up Operation	504102	
MS27039C4-12	Screw	4 Ea (4 ea)	90-Start up Operation	F124586	
NAS1149C0332R	Washer	28 Ea (28 ea)	90-Start up Operation	5056493	
NAS1149C0432R	Washer	4 Ea (4 ea)	90-Start up Operation	5030052-1	
NAS1149C0532R	Washer	10 Ea (10 ea)	90-Start up Operation	501473	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C4A	24	2,387	0
	AN3C6A	4	266	0
	AN5C7A	10	128	0
	D3391-011	1	0	0
	D3391-013	1	0	0
	D3391-015	1	0	0
	D3672-3	4	1,212	0
	D4095-041	1	11	0
	D4095-043	1	14	0
	D4095-045	1	10	0
	MS27039C4-12	4	153	0
	NAS1149C0332R	28	5,560	0
	NAS1149C0432R	4	2,407	0
	NAS1149C0532R	10	373	0

Part Specifications				
Specifications could not be found.				

Plex 5/14/18 10:28 AM Dart.Gagnon.Michelle

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Container No: S093748



Part: D412-742-041

Job No: 177478

Serial No/Batch: S093748

Revision: A/J

Inspector:

Exp Date:

Instructions:

Date: 07/19/18